



Dart Aerospace Ltd.
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RBW6405G04132-3G

Job Sheet 204214



Part No: RBW6405G04132-3G

Job Qty: 1 pcs

Part Name: Tail Rotor Duplex Bearing Install



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 12/5/19

Job Tracking No:

Due Date: 1/31/20

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG RBW6405G04132-3G Rev.E IPP Rev. A 19.03.08 New issue DP Verify DD

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Small Fab - 1	1 pcs	1/31/20		0.00	0.07	Small Fab - 1		MLK
							Small Fab - 2		
							Small Fab - 3		
							Small Fab - 4		
							Small Fab - 5		
							Small Fab - 6		
							Small Fab - 7		
							Small Fab - 8		
							Small Fab - 9		
110	QC 5	1 pcs	1/31/20		0.00	0.00	QC 5 - 10		DAS DEC 10 2019 40 9-89
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		
							QC 5 - 9		
							QC 5 - 50		
							QC 5 - 30		
							QC 5 - 40		
							QC 5 - 61		
							QC 5 - 81		
120	Packaging 3-1 - Stock - B4B	1 pcs	1/31/20		0.00	0.00	Packaging 3 - 1 - B4B		
							Packaging 3 - 2 - B4B		
							Packaging 3 - 3 - B4B		



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Container No: S238550



Part: RBW6405G04132-3G

Job No: 204214

Serial No/Batch: S238550

Revision: E

Inspector:

Exp Date:

Instructions:

Date: 12/09/19

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				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	DAS
				Packaging 3 - 8 - B4B	28
				Packaging 3 - 9 - B4B	9-89
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
130 QC 21 - FG				1 pcs	1/31/20
				0.00	0.00
				QC 21 - FG - 21	DAS
				QC 21 - FG - 70	21
				QC 21 - SA - 53	9-89

DEC 10 2019

Part Op 100 - Pick as per drawing.
 Descriptions: 110 - QC5- Inspect part completeness to step on W/O
 120 - Identify as per dwg & Stock Location:
 130 - QC21- Final Inspection - Work Order Release

GA143F

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
RBW6405G04132-3G-1	Hub Assembly	1 pcs (1 ea)	100-Small Fab - 1	5215468
RBW6405G04132-3G-4	Frame Assembly	1 pcs (1 ea)	100-Small Fab - 1	5217962

Job Allocations

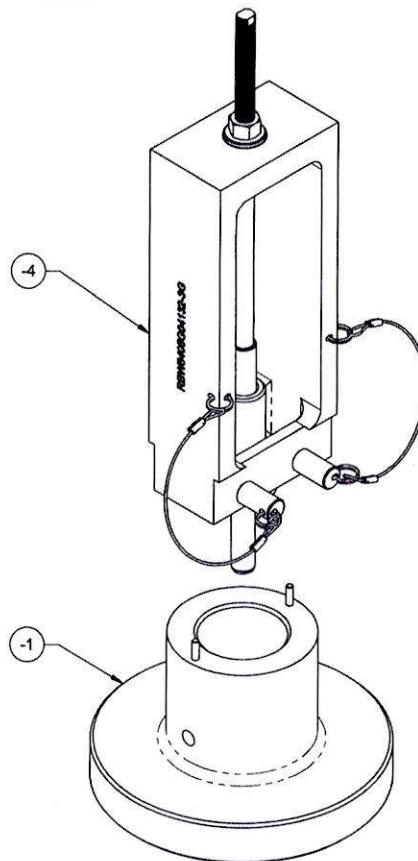
Operation	Component Part	Required	Inventory	Allocated
100-Small Fab - 1	RBW6405G04132-3G-1	1	1	0
	RBW6405G04132-3G-4	1	1	0

Part Specifications

Specifications could not be found.

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ITEM #	QTY	PART #	PART TITLE
-1	1	RBW6405G04132-3G-1	HUB ASSY
-4	1	RBW6405G04132-3G-4	FRAME ASSY



RBW6405G04132-3G T/R DUPLEX BEARING INSTALLATION

NOTES:

- 1) MATERIAL: N/A
- 2) HEAT TREAT: N/A
- 3) FINISH: N/A
- 4) TOLERANCES: X.X = +/- 0.1" / +/- 1"
X.XX = +/- 0.01" / +/- 0.5"
X.XXX = +/- 0.005" / +/- 0.1"
X.XXXX = +/- 0.0005" / +/- 0.05"
PARALLELISM, ECCENTRICITY AND SYMMETRY ABOUT ALL CENTER LINES = +/- 0.005"
- 5) UNITS: INCHES UNLESS OTHERWISE NOTED
- 6) IDENTIFICATION: N/A
- 7) THE TOOL ASSY MUST BE PACKAGED WITH A DESICCANT BAG INTO A TIGHT FITTING SEALED PLASTIC BAG

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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 204214 M15
15-12-05

SEE PDFs FOR OLDER REVs
TEMPLATE UPDATED PER DART HBY STANDARDS
ITEM -1 CHANGED FOR ITEM -2
ITEM -1 ASSY ADDED
ITEM -4 ASSY ADDED
ITEM -13 CHANGED FOR ITEM -5
ITEM -5 CHANGED FOR ITEM -6
ITEM -9 CHANGED FOR ITEM -8
ITEM -11 REMOVED AND REPLACED BY McMaster#91131A071
ITEM -15 DOWEL PIN McMaster#98381A511 CHANGED FOR ITEM 9
McMaster#97395A474
ITEM 10 McMaster#91732A232 ADDED
ITEM -3 MATERIAL WAS McMaster#92562A596 IS McMaster#92185A561,
DIMENSION .121 CHANGED FOR 0.121 +0/-0.005, DIMENSION .722
CHANGED FOR .72, R0.008 MAX ADDED
ITEM -2 DIMENSION .1874/.1869 CHANGED FOR .1875/.1867,
DIMENSION 2.362 CHANGED FOR 2.362 +0.005/-0, R0.015 MAX
ADDED, .03 X 45° CMF 2 PL ADDED, DIMENSION .08 X 45° 2PL
CHANGED FOR 3 PL DIMENSION 3.454 B.C CHANGED FOR 3.454 +/-
0.001, DIMENSION 1/4-28 UNF 2A CHANGED FOR 1/4"-28 HELICOIL,
MATERIAL WAS 6061 CLEAR ANODIZE IS 6061/7075 RED ANODIZE
ITEM -5 DIMENSION .514 CHANGED FOR .516, DIMENSION
1.4170/1.4164 CHANGED FOR 1.1250/1.1242, R0.008 MAX ADDED,
DIMENSION 0.02 X 45° CMF ADDED, ENGRAVING "MADE IN USA" AND
S/N REMOVED, DIMENSION .16 CHANGED FOR 0.157, DIMENSION .30
CHANGED FOR 0.295, DIMENSION .30" CHANGED FOR 30.4"
MATERIAL WAS 6061 CLEAR ANODIZE IS 6061/7075 RED ANODIZE
ITEM -6 MATERIAL WAS 4140 Q&T/4142 Q&T CAD PLATE YELLOW IS
4140(28-32Rd) BLACK OXIDE, DIMENSION .869 +/- .002 CHANGED FOR
0.860 +/- 0.002, DIMENSION .502 CHANGED FOR 0.499, ENGRAVING
REMOVED, DIMENSION .85 UNDERCUT CHANGED FOR MIN
UNDERCUT, THREAD RELIEF ADDED, DIMENSION .228 CHANGED
FOR 0.23, DIMENSION .193 CHANGED FOR 0.505 FROM THE
TANGENT POINT OF THE SHAFT, 0.02 X 45° CMF 2 PL ADDED,
CENTER DRILL ACCEPTABLE NOTE ADDED
ITEM -7 MATERIAL 4140 Q&T/4142 Q&T CAD PLATE YELLOW
CHANGED FOR 4140 (28-32 RC) ZINC PLATE TYPE 2 CLASS 2,
DIMENSION .674 +/- .002 CHANGED FOR 0.670, ALL CHAMFER
REPLACED BY 0.08 X 45° CMF 4 PL
ITEM -8 MATERIAL 4140 Q&T/4142 Q&T CAD PLATE YELLOW
CHANGED FOR 4140 (28-32 RC) ZINC PLATE TYPE 2 CLASS 2,
DIMENSION .21 CHANGED FOR 0.210, DIMENSION .16 CHANGED FOR
0.157, DIMENSION 45° CHANGED FOR 45.0°, R0.03 ADDED, CENTER
DRILL NOTE ADDED

19-580

REV.	DESCRIPTION	ECN #	BY
DESIGN	VM		
DRAWN	VM		
CHECKED	VM		
MFG. APPR.	RG		
APPROVED	VP		
DATE	3/1/2019		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
TOOL PART # RBW6405G04132-3G	REV. E
TITLE T/R DUPLEX BEARING INSTALLATION	SHEET 1 OF 9
SCALE NTS	Ⓢ
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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					